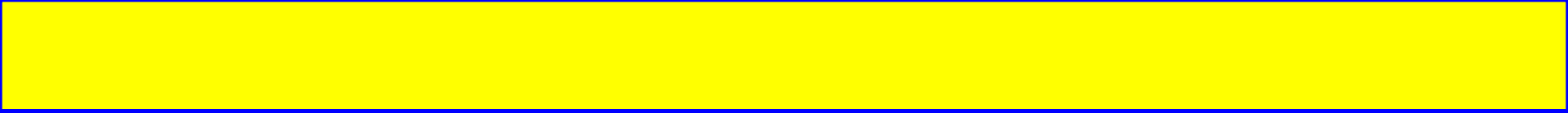




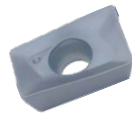
Insert Test Results



1. CASE STUDY - APKT 1003PDTR

► Test Condition

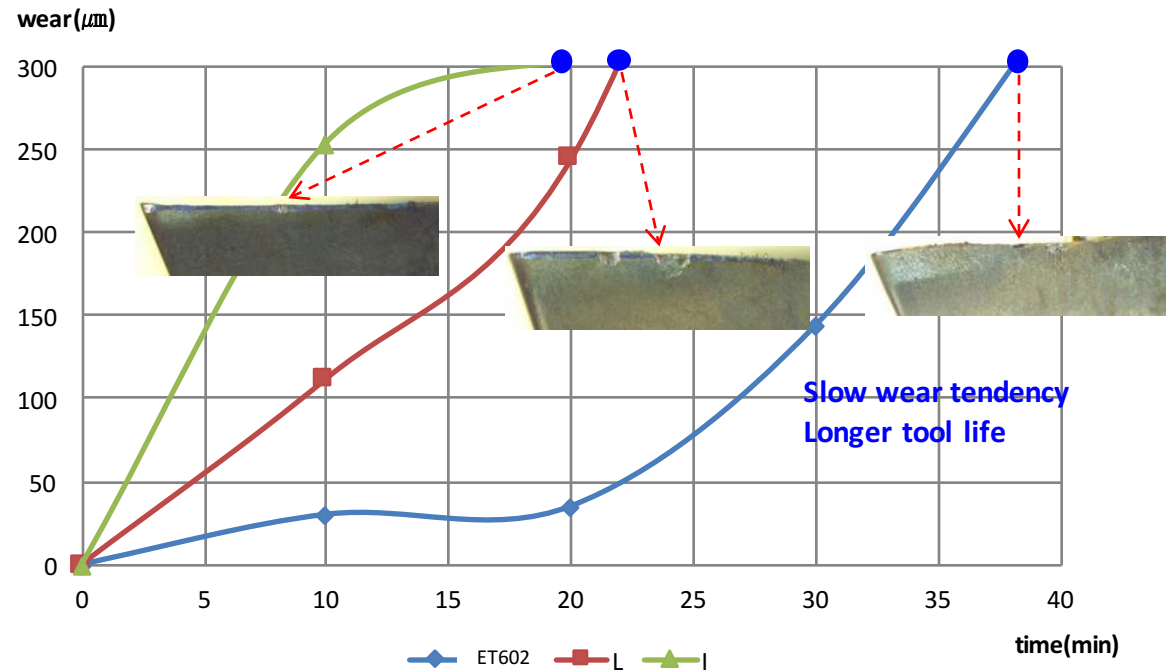
Workpiece (Alloy tool steel)	DIN : X100CrMoV5 1 AISI : D2 JIS : SKD11
Workpiece HB	210~220
Workpiece size	150*200*120
Vc(m/min)	140
fz(mm/tooth)	0.1
a_p/a_e (mm)	8 / 3
Coolant	Dry



► Test samples

Designation	Grade	Cutter
APKT 1003PDTR	ET602	Ø20
APKT 1003PDTR	L	
APKT 1003PDER	I	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

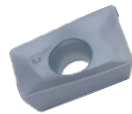
► Tool life comparison results :

- 1) ET602 had best tool life result compared to others.
- 2) ET602 showed slow wear tendency compared to others.

2. CASE STUDY - APKT 1003PDTR

► Test Condition

Workpiece (Stainless steel)	DIN : X2CrNi19-11 AISI : 304 JIS : SUS304
Workpiece HB	170~180
Workpiece size	300*80*150
Vc(m/min)	180
fz(mm/tooth)	0.08
a _p /a _e (mm)	8 / 3
Coolant	Dry



► Test samples

Designation	Grade	Cutter
APKT 1003PDTR	ET602	∅20
APKT 1003PDTR	L	
APKT 1003PDER	I	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

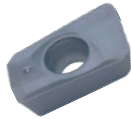
► Tool life comparison results :

- 1) ET602 had best tool life results compared to others.
- 2) ET602 showed slow wear tendency compared to others.

3. CASE STUDY - APMT 1135PDTR

► Test Condition

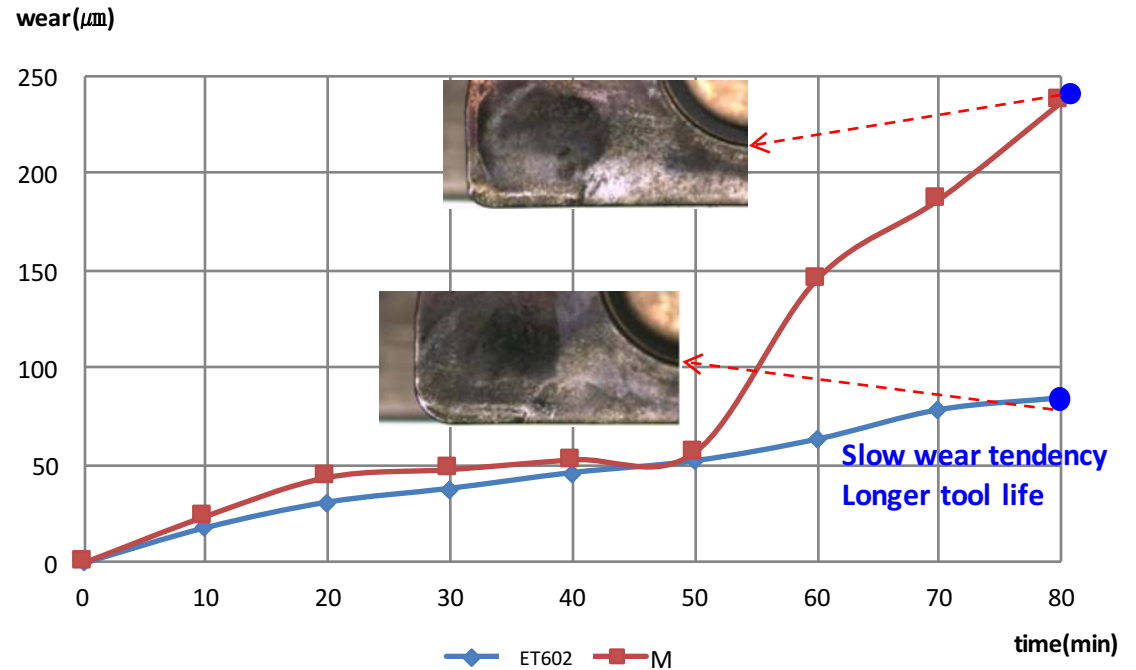
Workpiece (Alloy steel)	DIN : 42CrMo4 AISI : 4140 JIS : SCM440
Workpiece HB	190~200
Workpiece size	300*60*150
Vc(m/min)	180
fz(mm/tooth)	0.15
a _p /a _e (mm)	2 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
APMT 1135PDTR	ET602	Ø20
APMT 1135PDR	M	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

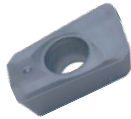
► Tool life comparison results :

- 1) ET602 had best tool life result compared to other.
- 2) ET602 showed slow wear tendency compared to other.

4. CASE STUDY - APMT 1135PDTR

► Test Condition

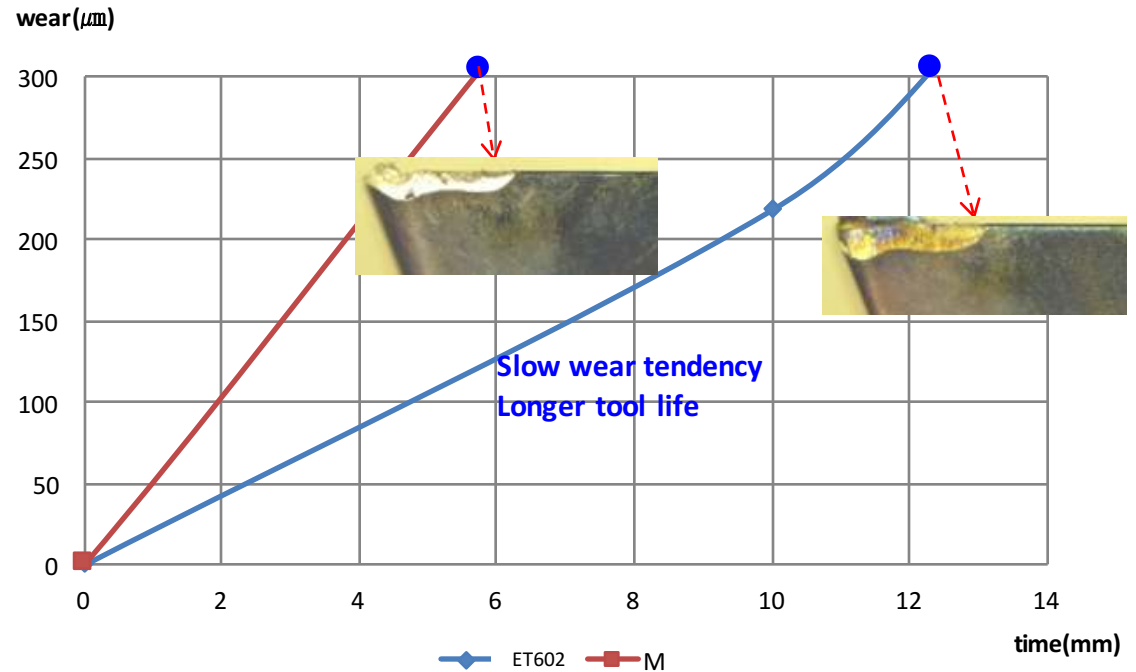
Workpiece (Alloy tool steel)	DIN : X100CrMoV5 1 AISI : D2 JIS : SKD11
Workpiece HB	210~220
Workpiece size	150*200*120
Vc(m/min)	140
fz(mm/tooth)	0.15
a _p /a _e (mm)	2 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
APMT 1135PDTR	ET602	Ø20
APMT 1135PDR	M	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

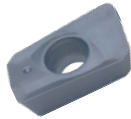
► Tool life comparison results :

- 1) ET602 had best tool life result compared to other.
- 2) ET602 showed slow wear tendency compared to other.

5. CASE STUDY - APMT 1135PDTR

► Test Condition

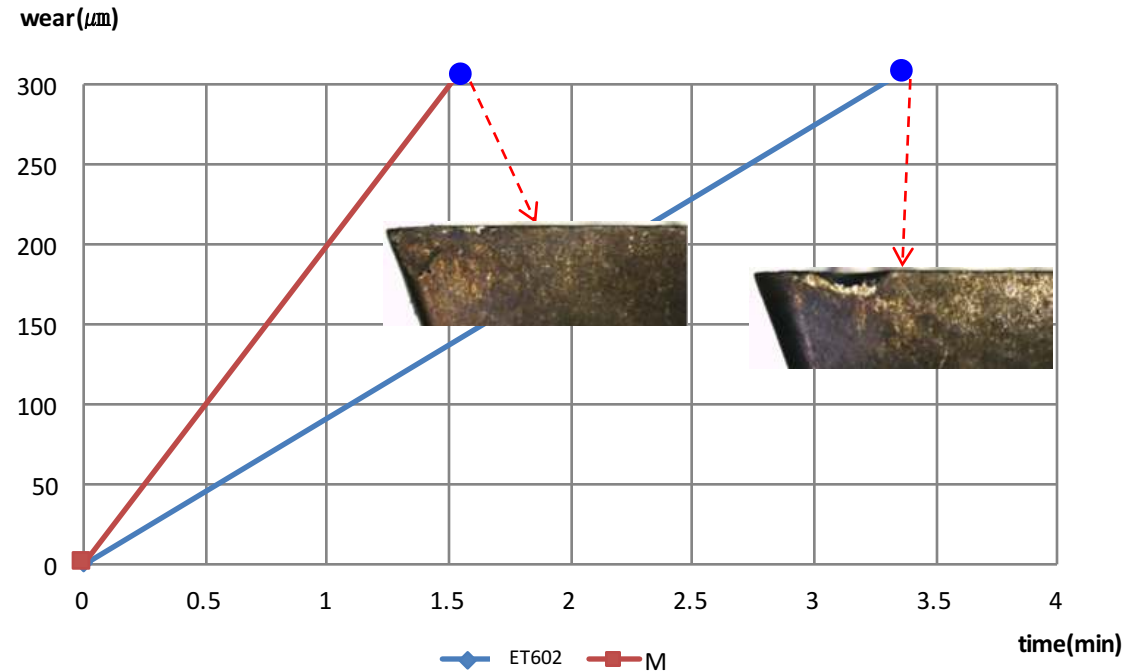
Workpiece (Stainless steel)	DIN : X2CrNi19-11 AISI : 304 JIS : SUS304
Workpiece HB	170~180
Workpiece size	300*80*150
Vc(m/min)	140
fz(mm/tooth)	0.12
a _p /a _e (mm)	2 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
APMT 1135PDTR	ET602	Ø20
APMT 1135PDR	M	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

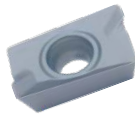
► Tool life comparison results :

- 1) ET602 had best tool life result compared to other.
- 2) ET602 showed slow wear tendency compared to other.

6. CASE STUDY - APMT 1604PDTR

► Test Condition

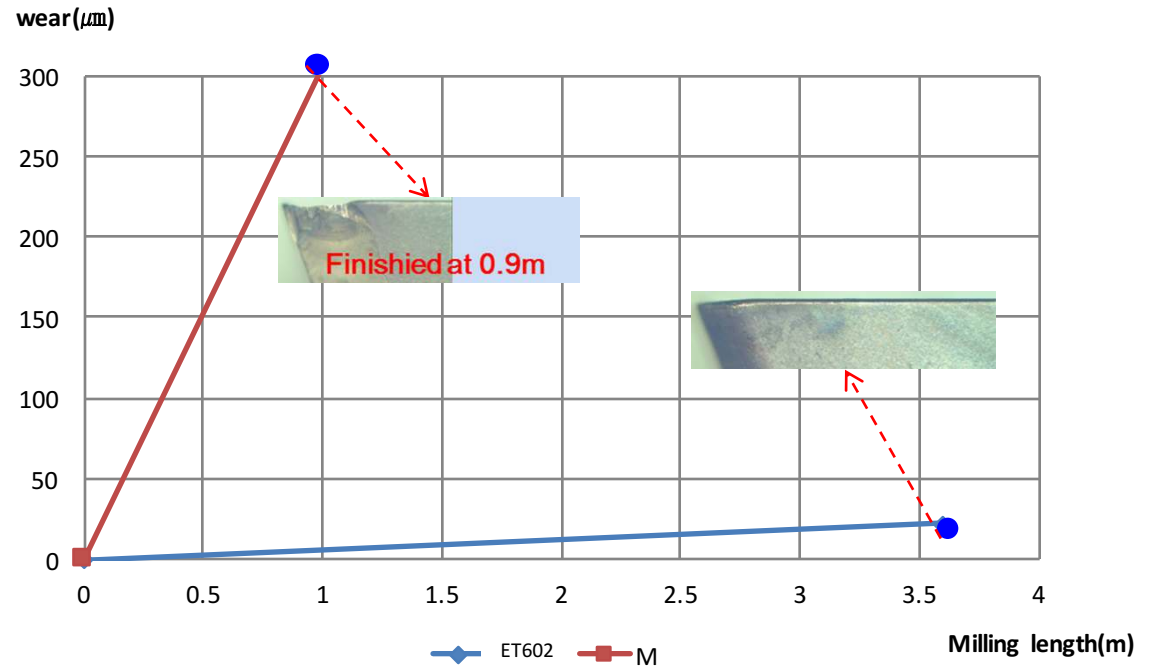
Workpiece (Alloy steel)	DIN : 42CrMo4 AISI : 4140 JIS : SCM440
Workpiece HB	270~290
Workpiece size	200*300*150
Vc(m/min)	200
fz(mm/tooth)	0.18
a _p /a _e (mm)	2 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
APMT 1604DTR	ET602	Ø50
APMT 1604PDR	M	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

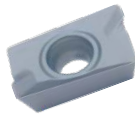
► Tool life comparison results :

- 1) ET602 had best tool life result compared to other.
- 2) ET602 showed slow wear tendency compared to other.

7. CASE STUDY - APMT 1604PDTR

► Test Condition

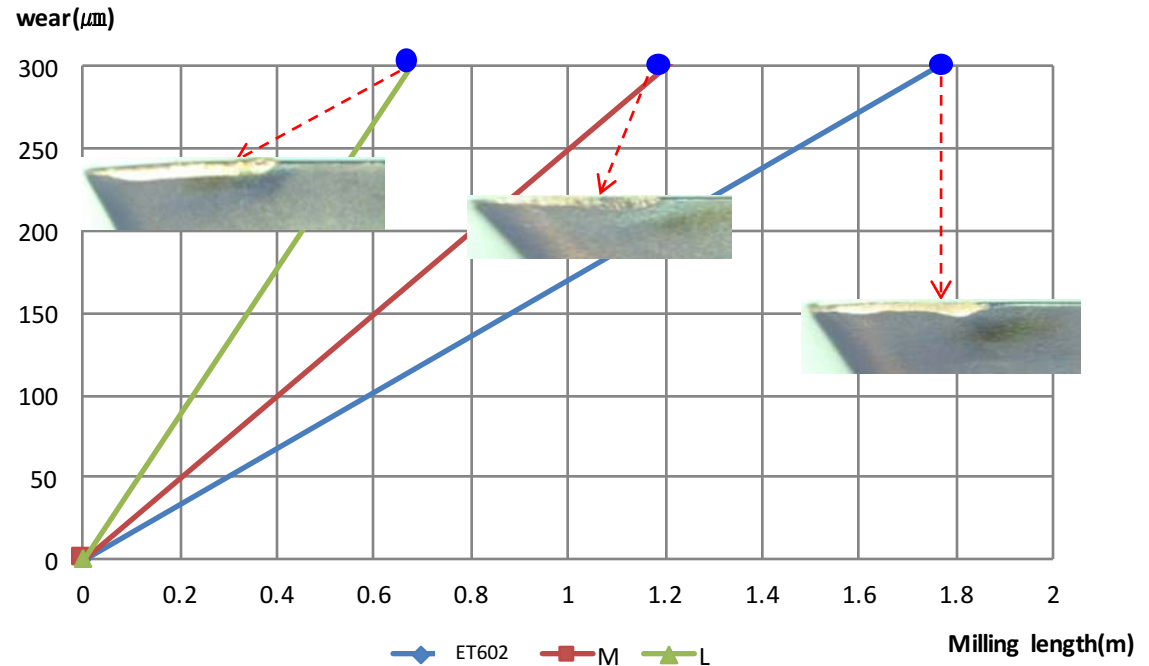
Workpiece (Alloy tool steel)	DIN : X100CrMoV5 1 AISI : D2 JIS : SKD11
Workpiece HB	190~200
Workpiece size	120*100*150
Vc(m/min)	180
fz(mm/tooth)	0.12
a _p /a _e (mm)	2 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
APMT 1604PDTR	ET602	Ø50
APMT 1604PDER	M	
APMT 1604PDTR	L	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

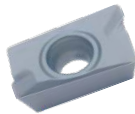
► Tool life comparison results :

- 1) ET602 had best tool life result compared to others.
- 2) ET602 showed slow wear tendency compared to others.

8. CASE STUDY - APMT 1604PDTR

► Test Condition

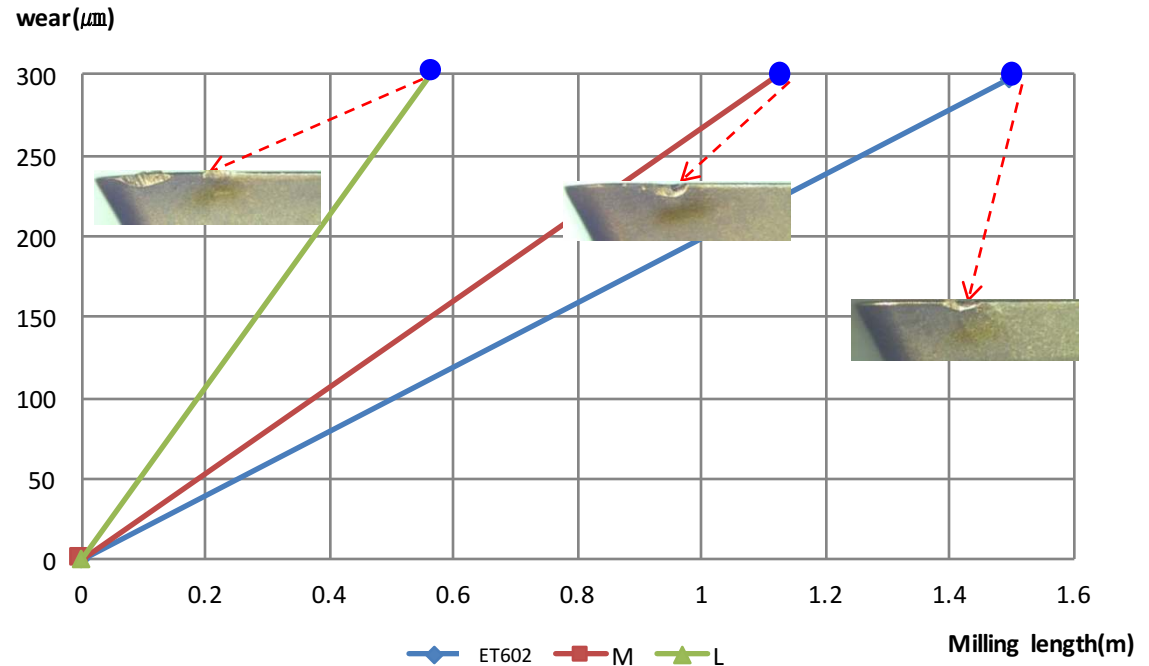
Workpiece (Stainless steel)	DIN : X2CrNi19-11 AISI : 304 JIS : SUS304
Workpiece HB	130~140
Workpiece size	300*60*150
Vc(m/min)	220
fz(mm/tooth)	0.08
a _p /a _e (mm)	2 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
APMT 1604PDTR	ET602	Ø50
APMT 1604PDER	M	
APMT 1604PDTR	L	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

► Tool life comparison results :

- 1) ET602 had best tool life result compared to others.
- 2) ET602 showed slow wear tendency compared to others.

9. CASE STUDY - RDMT 1204M0

► Test Condition

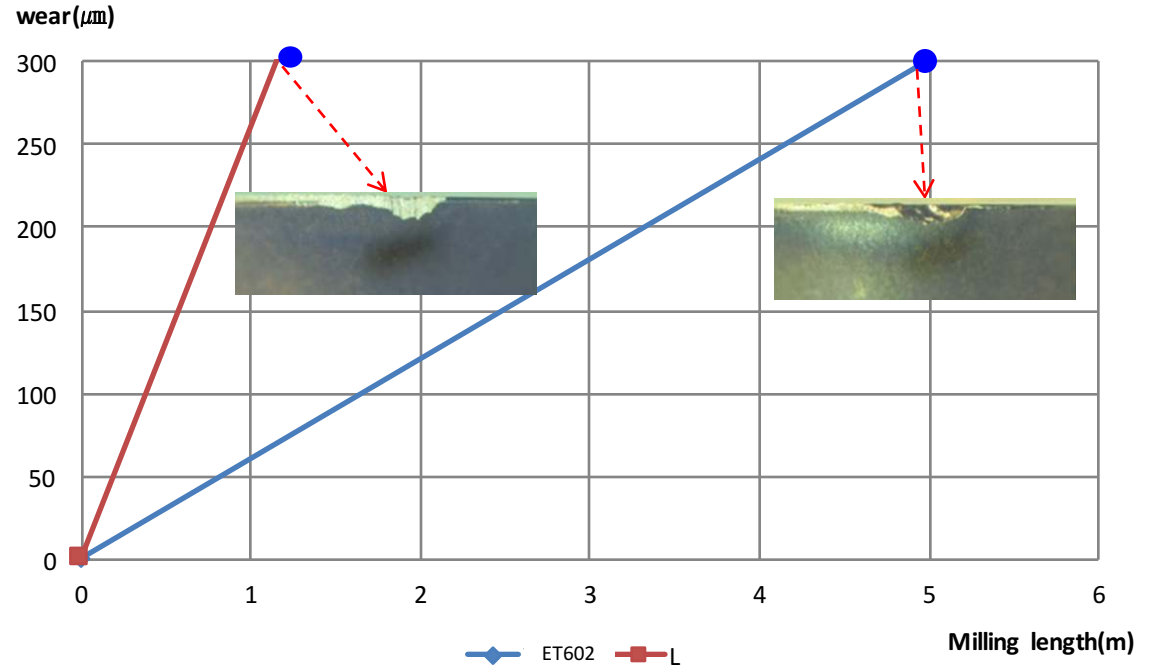
Workpiece (Alloy tool steel)	DIN : X100CrMoV5 1 AISI : D2 JIS : SKD11
Workpiece HB	200~210
Workpiece size	120*100*150
Vc(m/min)	120
fz(mm/tooth)	0.20
ap/ae(mm)	1.5 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
RDMT 1204M0	ET602	Ø50
RDMT 1204M0	L	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

► Tool life comparison results :

- 1) ET602 had best tool life result compared to other.
- 2) Et02 showed slow wear tendency compared to other.

10. CASE STUDY - RDMT 1204M0

► Test Condition

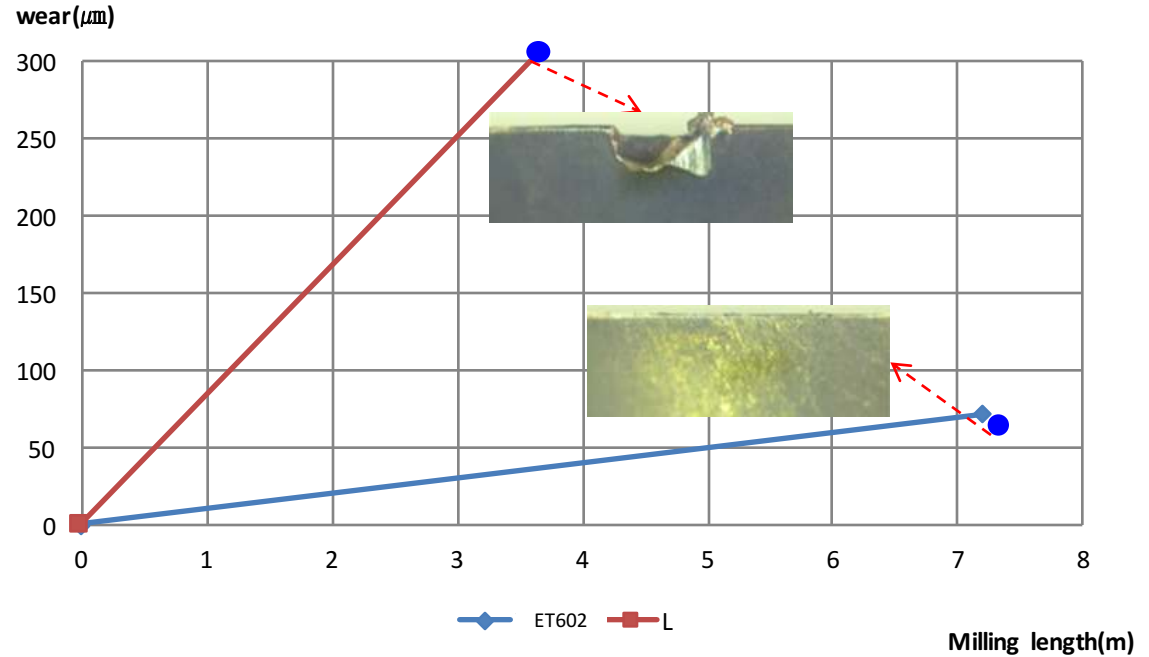
Workpiece (Stainless steel)	DIN : X2CrNi19-11 AISI : 304 JIS : SUS304
Workpiece HB	150~160
Workpiece size	300*60*150
Vc(m/min)	180
fz(mm/tooth)	0.24
a _p /a _e (mm)	1.5 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
RDMT 1204M0	ET602	Ø50
RDMT 1204M0	L	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

► Tool life comparison results :

- 1) ET602 had best tool life result compared to other.
- 2) ET602 showed slow wear tendency compared to other.

11. CASE STUDY - RPMT 1204M0

► Test Condition

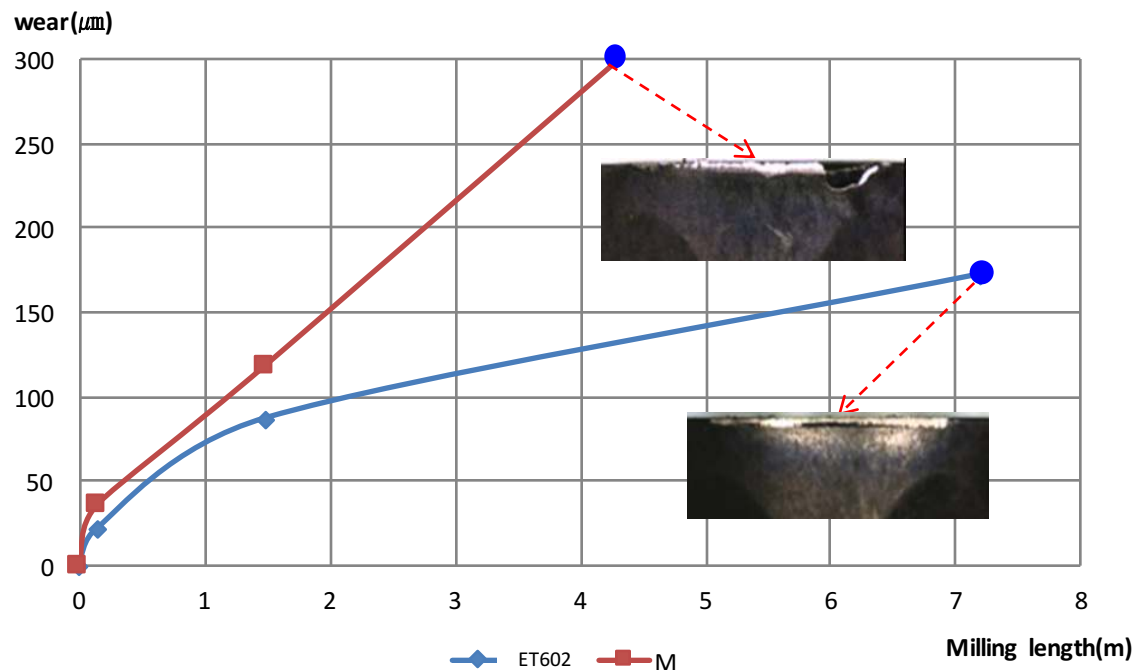
Workpiece (Alloy tool steel)	DIN : X100CrMoV5 1 AISI : D2 JIS : SKD11
Workpiece HB	210~230
Workpiece size	120*100*150
Vc(m/min)	120
fz(mm/tooth)	0.23
a _p /a _e (mm)	1.5 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
RPMT 1204M0	ET602	Ø40
RPMT 1204M0	M	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

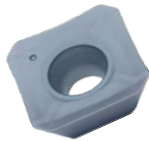
► Tool life comparison results :

- 1) ET602 had best tool life result compared to other.
- 2) ET602 showed slow wear tendency compared to other.

12. CASE STUDY - SEKT 1204AFTN

► Test Condition

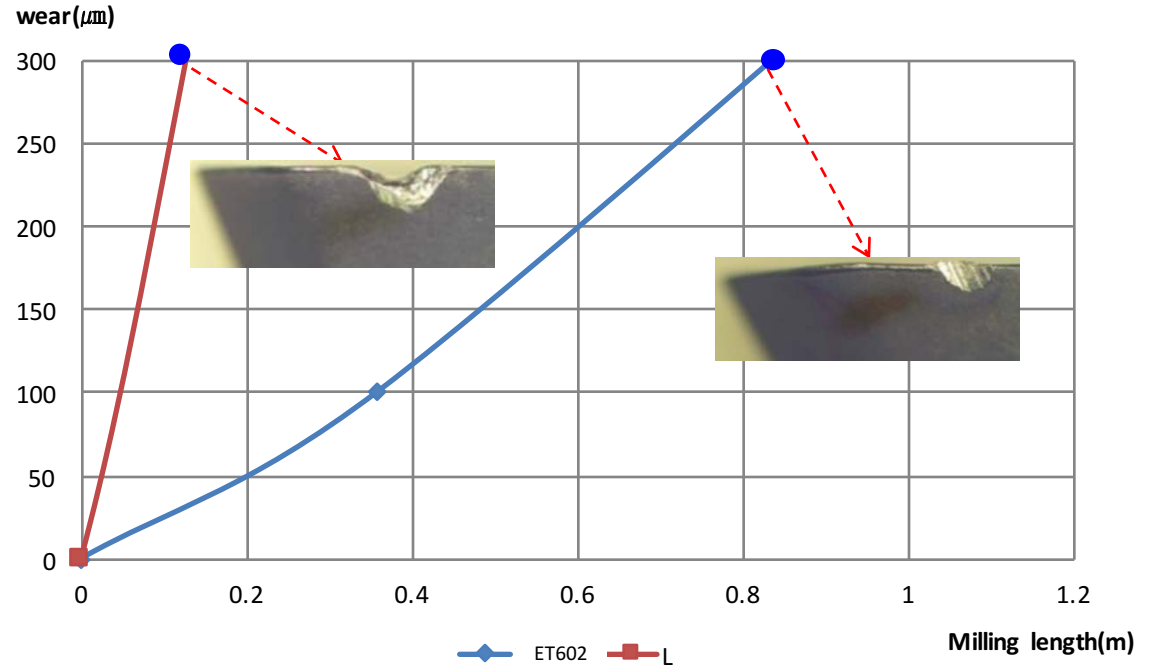
Workpiece (Alloy tool steel)	DIN : X100CrMoV5 1 AISI : D2 JIS : SKD11
Workpiece HB	210~230
Workpiece size	120*100*150
Vc(m/min)	120
fz(mm/tooth)	0.2
a _p /a _e (mm)	1.5 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
SEKT 1204AFTN	ET602	Ø100
SEKT 1204AFTN	L	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

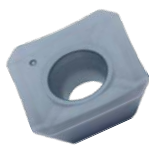
► Tool life comparison results :

- 1) ET602 had best tool life results compared to other.
- 2) ET602 showed slow wear tendency compared to other.

13. CASE STUDY - SEKT 1204AFTN

► Test Condition

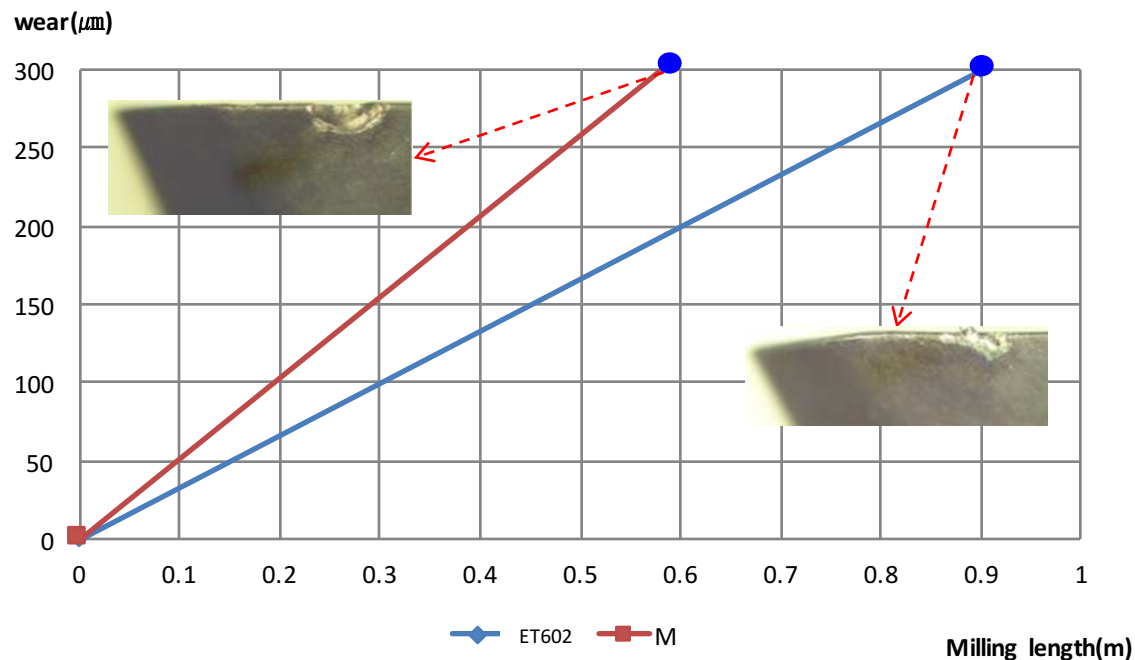
Workpiece (Stainless steel)	DIN : X2CrNi19-11 AISI : 304 JIS : SUS304
Workpiece HB	170~180
Workpiece size	300*60*150
Vc(m/min)	180
fz(mm/tooth)	0.2
a _p /a _e (mm)	1.5 / 20
Coolant	Dry



► Test samples

Designation	Grade	Cutter
SEKT 1204AFTN	ET602	Ø100
SEMT 13T3AGSN	M	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

► Tool life comparison results :

- 1) ET602 had best tool life result compared to other.
- 2) ET602 showed slow wear tendency compared to other.

15. CASE STUDY – WCMX 06T308

► Test Condition

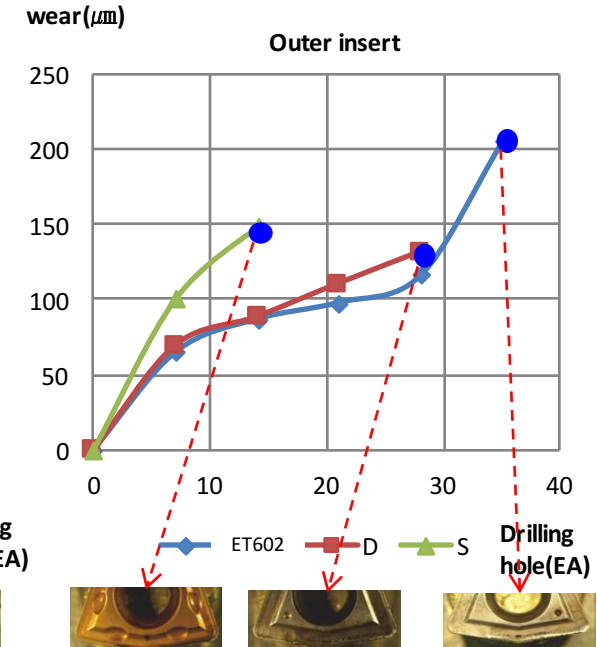
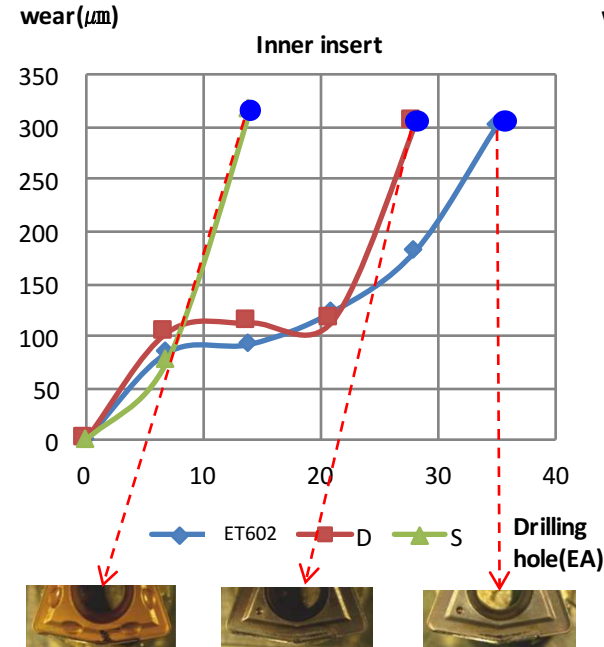
Workpiece (Stainless steel)	DIN : X100CrMoV5 1 AISI : D2 JIS : SKD11
Workpiece HB	180~190
Workpiece size	300*60*200
Vc(m/min)	120
fz(mm/tooth)	0.1
a _p /a _e (mm)	Through 60mm
Coolant	Wet



► Test samples

Designation	Grade	Holder
WCMX 06T308	ET602	Ø35
WCMX 06T308	D	
WCMX 06T308	S	

► Test result



※ Above pictures were described at the end of the test.

※ Test finishing wear value : 300um(flank wear)

► Tool life comparison results :

- 1) ET602 had best tool life result compared to others.
- 2) ET602 showed slow wear tendency compared to others.